

SHIP 10/4/15

Work Order ID 57094



Page 1

Monday, March 22, 2010 8:26:01 AM

Item ID: D3914-041

Accept



Setup Start



Revision ID:

LID

Stop



Item Name: Upper Basket ~~Log~~ Assembly, Aft

Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-3-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

PA1

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod. Batch: 111679  
Large Fab

0.00

Memo

0.00

1- assemble ribs , weld as per dwg D3914  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914

CPC

CPC

CPL 10-04-13  
M 10/04/14

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10.04.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 57094**

Monday, March 22, 2010 8:26:01 AM

Page 2

Item ID: D3914-041

Accept

Revision ID:

Item Name: Upper Basket Lug Assembly, Aft

Start Date: 3/22/2010 Start Qty: 1.00

Required Date: 3/31/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/15

Memo

0.00

④

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M105642

START: 7:30AM

=&gt; H 10/04/15

Memo

TEMP: 320°

0.00

FIN: 8:00AM

X1

Ø

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M113545

0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

9/5/10/04/15 ①

①

BK 10-4-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, March 22, 2010 8:26:01 AM

Page 3

Item ID: D3914-041

Accept

Revision ID:

Item Name: Upper Basket Lug Assembly, Aft

Start Date: 3/22/2010 Start Qty: 1.00

Required Date: 3/31/2010 Req'd Qty: 1.00




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start  
Stop

Cust Item ID:  
Customer:

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							<i>ES 10/04/15</i> ①
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>6-A</i> <i>U10 57564</i> Memo	0.00  0.00							<i>ES 10/04/15</i> ①
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>10/04/15</i> <i>MF</i> <i>10-4-15</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 22, 2010 8:26:01 AM

Page 1

Work Order ID: 57094



Parent Item: D3914-041



Parent Item Name: Upper Basket Lug Assembly, Aft

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	35.0000	2.0000 			
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*Lpl 10.04.12*

## Warehouse

## Loc Qty

## Loc Code

*B57185 → 2*

## Location

Main Warehouse

WA

35

46086

2

48428

1

50872

1

51120

2

51745

2

55918

27

D3914-1 		Manufactured	No			100	Each	0.0000	2.0000 			
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*B57095 → 2 Lpl 10.04.12*

Rib D3914-7 		Manufactured	No			100	Each	0.0000	2.0000 			
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*B57096 → 2 Lpl 10.04.12*

Rib D4016-3 		Manufactured	No			100	Each	0.0000	3.0000 			
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*B56950 → 3 Lpl 10.04.12*

Hinge Half, Lid D4018-5 		Manufactured	No			100	Each	0.0000	9.0000 			
--------------------------------	--	--------------	----	--	--	-----	------	--------	------------	--	--	--

*B57097 → 9 Lpl 10.04.12*

Rib D4020-5 		Manufactured	No			100	Each	0.0000	1.0000 			
--------------------	--	--------------	----	--	--	-----	------	--------	------------	--	--	--

*B56989-1 Lpl 10/04/14*

Mesh (350 Basket Long, Lid)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 22, 2010 8:26:01 AM

Page 2

Work Order ID: 57094



Parent Item: D3914-041



Parent Item Name: Upper Basket Lug Assembly, Aft

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D4021-3

Manufactured

No

100

Each

1.0000

1.0000



Data Plate

357109 → 1 Cpl 10.04.12

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

1

56050

1

D4035-041

Manufactured

No

100

Each

0.0000

1.0000



Lid Rib Assembly, Fwd (350 Basket)

D4035-043

Manufactured

No

100

Each

0.0000

1.0000



Lid Rib Assembly, Aft (350 Basket)

D2728-3

Manufactured

No

140

Each

0.0000

1.0000



Dart Logo label

D4086-210

Manufactured

No

140

Each

0.0000

1.0000



Placard, Max Load

322553 (12)

356978 (12)

Cpl 10/04/15

Cpl 10/04/15

Monday, March 22, 2010 8:26:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

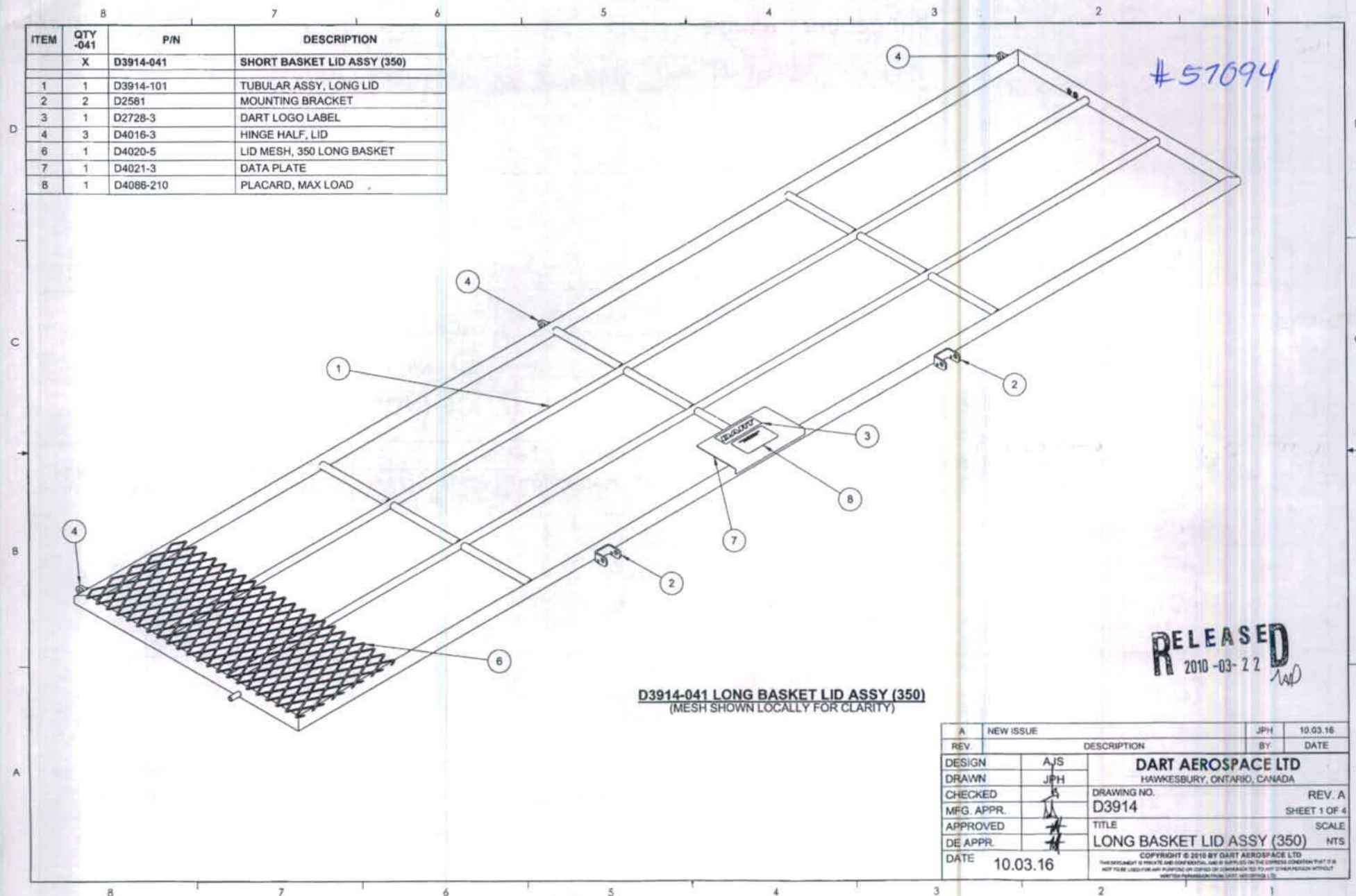
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

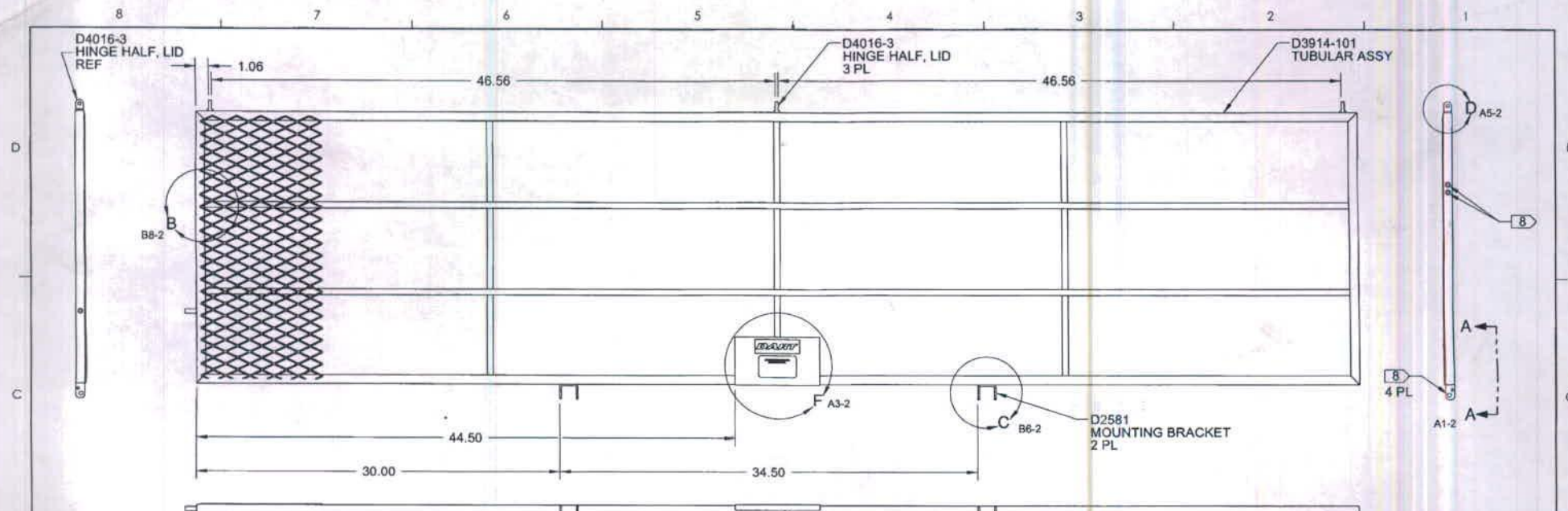
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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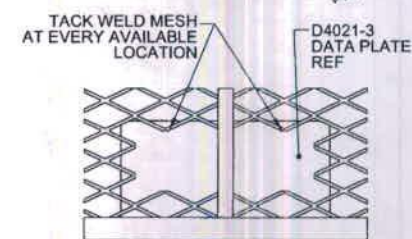
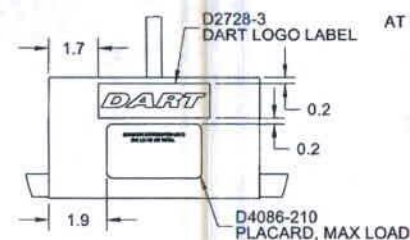
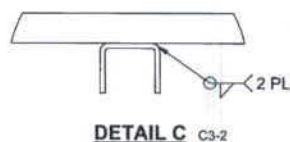
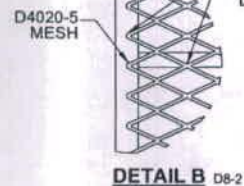
**NOTE:** Date & initial all entries

#57094



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.35 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

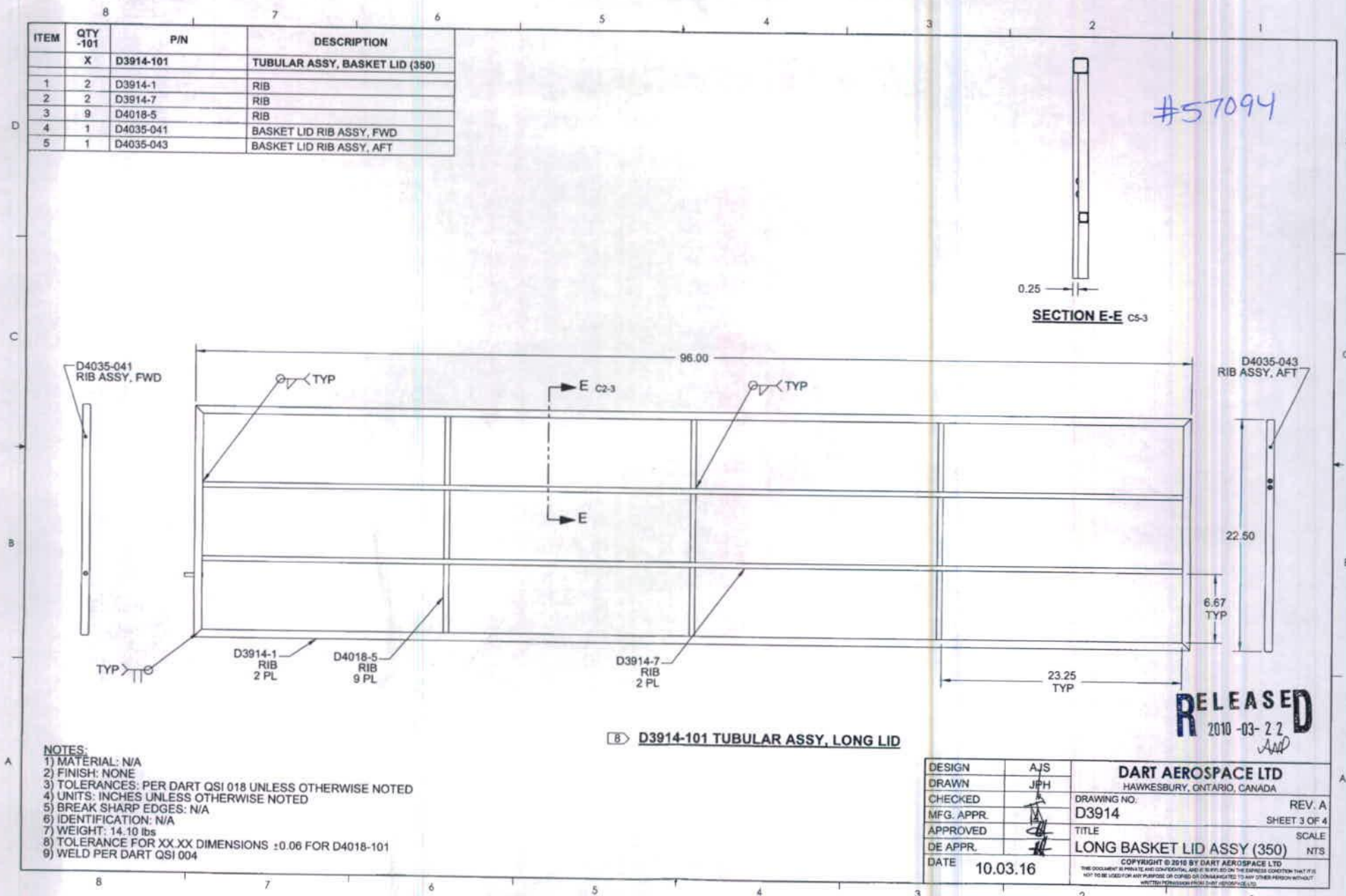
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. A
MFG. APPR.	1	D3914	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED  
2010-03-22





ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

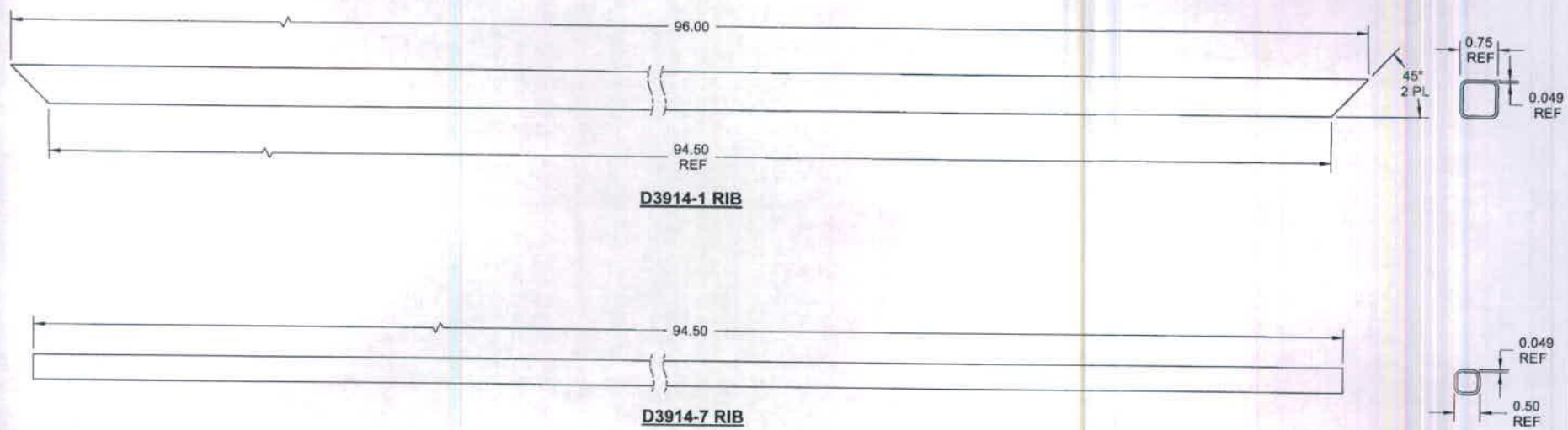


- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.10 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
  - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3914	REV. A
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
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DATE	10.03.16		



#57094



- NOTES:
- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
  - 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED  
2010-03-22  
MD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>A</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>A</del>	D3914	SHEET 4 OF 4
APPROVED	<del>A</del>	TITLE	SCALE
DE APPR.	<del>A</del>	LONG BASKET LID ASSY (350)	NTS
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